


Date: Wednesday, 14/01/2009 3:22:59 PM  
 User: Melanie Fauteux

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ANGLE	
Job Number : 44758		
Estimate Number : 13642		
P.O. Number :	Part Number : D37083	
This Issue : 14/01/2009 S.O. No. :	Drawing Number : D3708 PRELIM	
Prsht Rev. : NC	Project Number : N/A	
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : PRELIM	
Previous Run : 05064	Material :	
Written By :	Due Date : 16/01/2009	Qty: 1 Um: Each
Checked & Approved By : <u>MF 09-01-14</u>		
Comment : Est Rev:A 08-10-31 new issue DD verified by:EC		

## Additional Product

PRELIMINARY ISSUE

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6A750W0625	angle .750 x .750 x .625w
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Comment: Qty.: 1.5968 f(s)/Unit Total : 1.5968 f(s)  
 angle .750 x .750 x .625w

M107983

FF 09/01/15

①

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: 1- cut to length as per dwg  
 2- mark, cut notch and deburr as per dwg  
 3- form and bend angle as per dwg D3708 using DT9019 template

FF 09/01/15

①

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

ENGINEERING APPROVAL

Borowis ①

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1  
 Chemical Conversion Coat as per QSI 005 4.1

FD 09/02/06

①

5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SK 04-02-09 ①

6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1  
 Identify and Stock  
 Location 129

9/5/09

①

SD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Wednesday, 14/01/2009 3:22:59 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 44758

Part Number: D37083

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/09

Job Completion



MF  
09-06-01

POSITIVE RECALL

EFFECTIVE 09/06/09 AUTH h

RELEASED h DATE 09/06/09

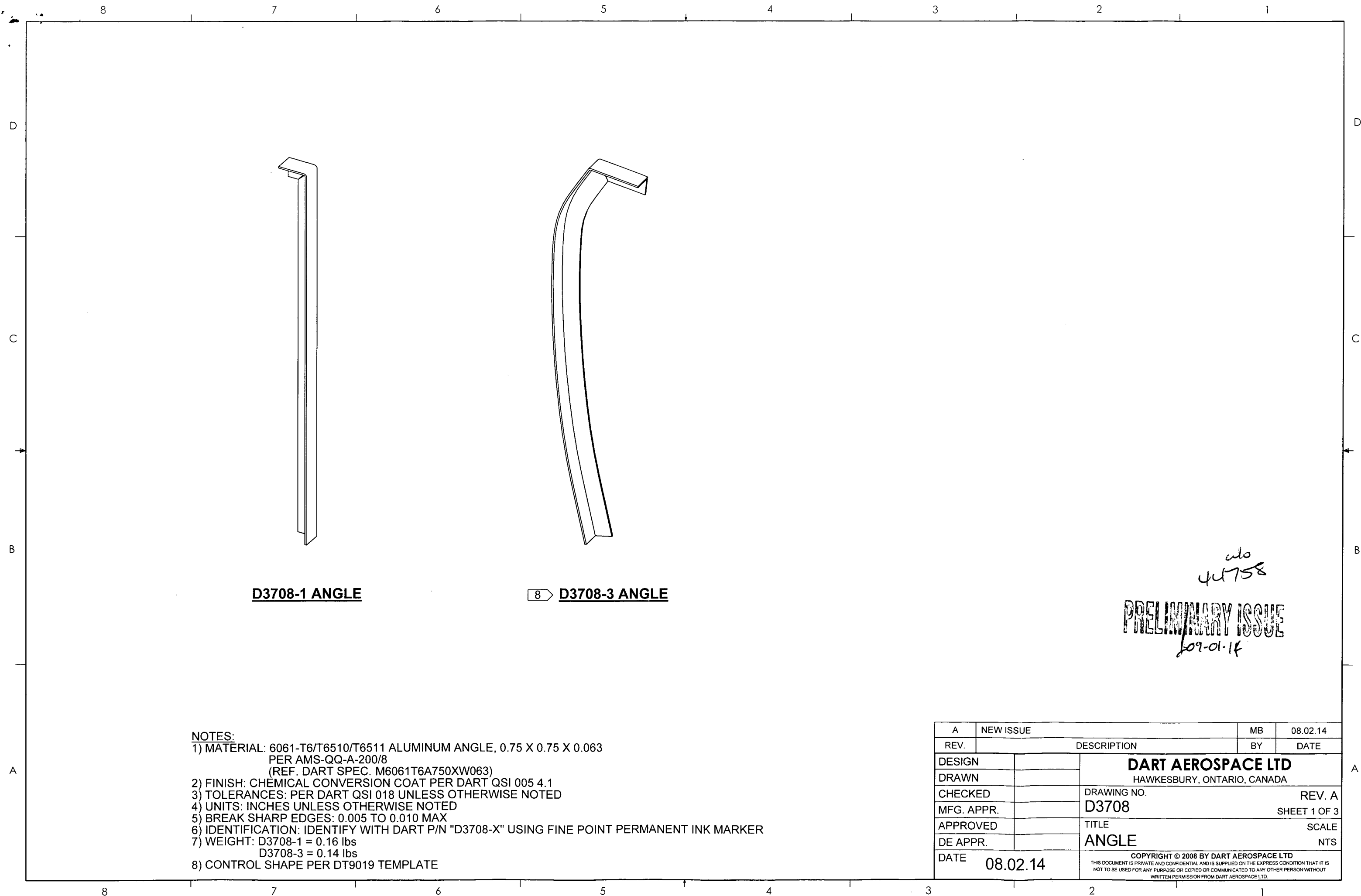
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

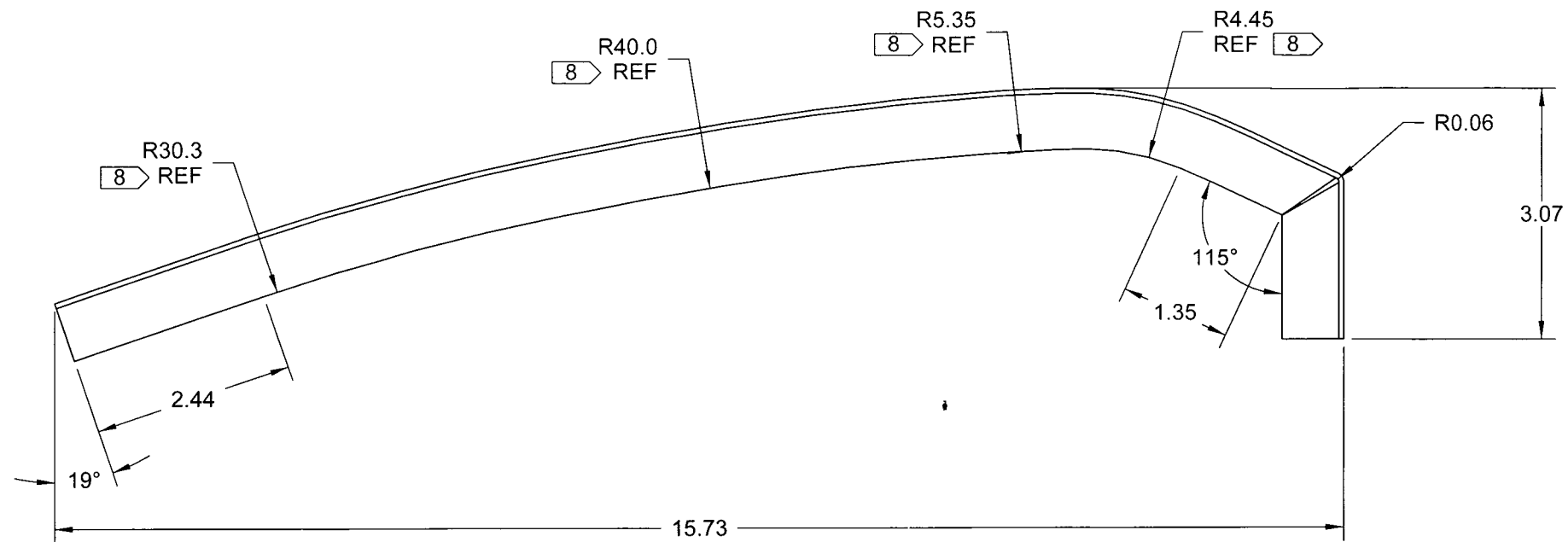
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

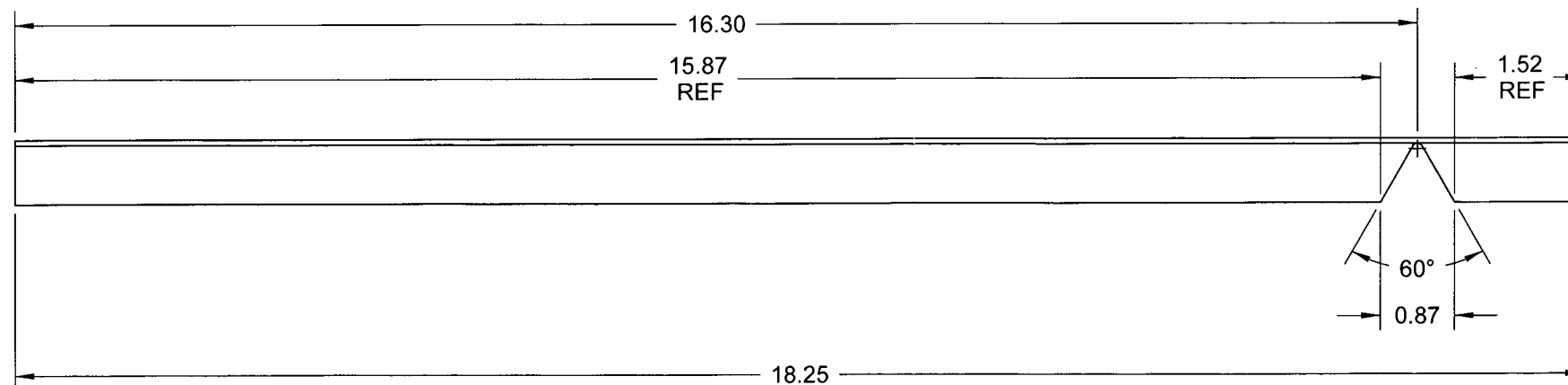
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

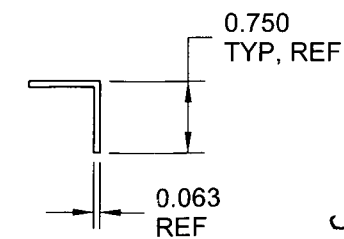




**D3708-3 ANGLE**  
(MAKE FROM D3708-3F)



**D3708-3F FLAT PATTERN ANGLE**



**PRELIMINARY ISSUE**  
08.02.14

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D3708</b>	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		<b>ANGLE</b>	NTS
DATE	<b>08.02.14</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



**D3708-1 ANGLE**



**D3708-3 ANGLE**

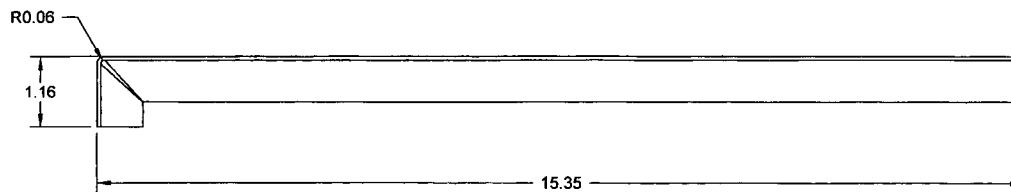
*Wb 44758*

**NOTES:**

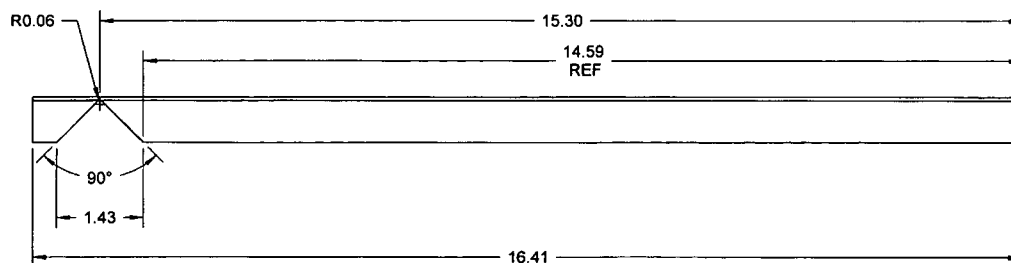
- 1) MATERIAL: 6061-T6/T6510/T6511 ALUMINUM ANGLE, 0.75 X 0.75 X 0.063  
PER AMS-QQ-A-200/8  
(REF. DART SPEC. M6061T6A750XW063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3708-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3708-1 = 0.16 lbs  
D3708-3 = 0.14 lbs
- 8) CONTROL SHAPE PER DT9019 TEMPLATE

**RELEASED**  
*08/02/14*

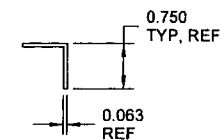
A		NEW ISSUE		MB	08.02.14
REV.		DESCRIPTION		BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA			
DRAWN					
CHECKED		DRAWING NO.		REV. A	
MFG. APPR.		D3708		SHEET 1 OF 3	
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**D3708-1 ANGLE**  
(MAKE FROM D3708-1F)



**D3708-1F FLAT PATTERN**

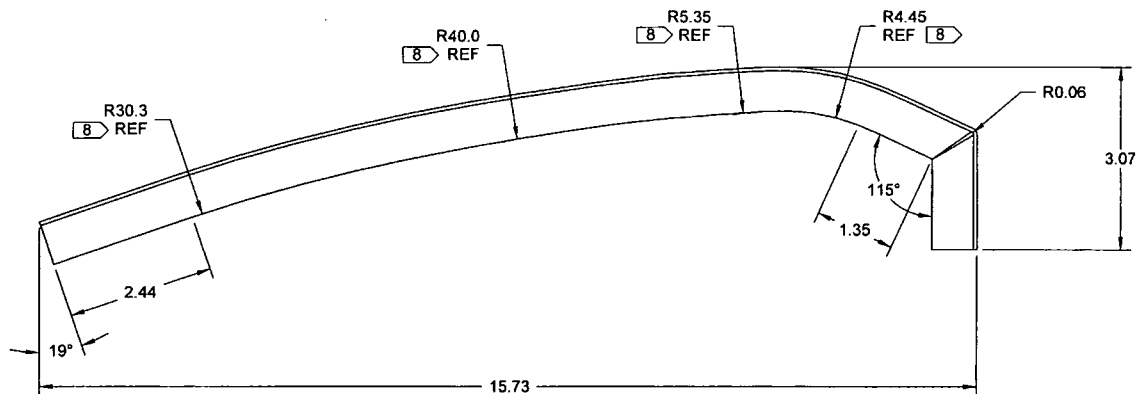


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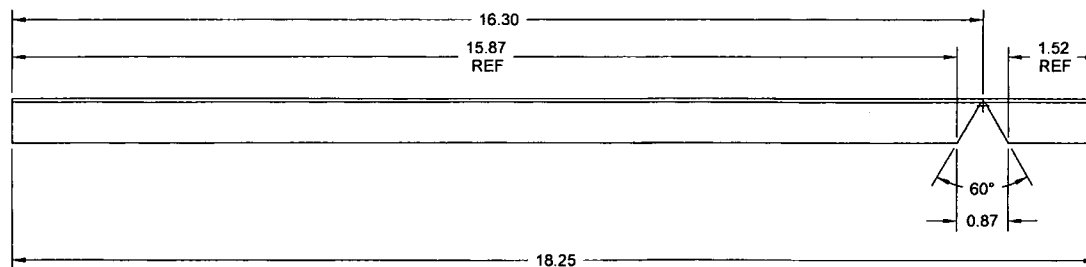
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09/24/09

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MFG. APPR.		D3708	SHEET 2 OF 3
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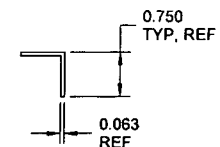




**D3708-3 ANGLE**  
(MAKE FROM D3708-3F)



**D3708-3F FLAT PATTERN ANGLE**



**RELEASED**  
09/04/09 MB

44758

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